

Date: Tuesday, 01/04/2008 12:52:50 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MIRROR BRACKET
Job Number : 36886A	
Estimate Number : 10143	
P.O. Number :	Part Number : D20135
This Issue : 01/04/2008 S.O. No. :	Drawing Number : D2013 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 36466A01	Material :
Written By : _____	Due Date : 28/01/2008 Qty: 4 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:A New Issue 05-11-01 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 1.8165 f(s)/Unit Total : 7.2660 f(s)
 Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless Tubing
 (M304TR0.750W.049)
 Batch: 1107518

SS 08/07/10

2.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

- 1-Punch as per template D2013-T5 and Dwg D2013
- 2-Flatten ends of D2013-5 tube as per Dwg D2013 using DT8545
- 3-Bend (1) tube as per Dwg D2013 using Jig DT8201 Identify as D2013-5.
- 4-Deburr as required

SS 08/04/10

EB 08/04/14 (4)

FF 08-04-15

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

SS 08/07/10 (4)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

241

8/7/10

(4)

30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2013-5 PAR #: N/A Fault Category: Prod/Prod. Ass' made small NCR: Yes No DQA: D Date: 08/07/15
QA: N/C Closed: D Date: 08/07/15

NCR: <u>36886A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/15	2	1 mirror bracket bend wrong. Human error. RC empty switched the orientation of the strut and bent in wrong location	<u>Postul2</u>	Destroyed and Scrap. and Replace. Label B* and P/n for small strut.	08/04/15 ff	<u>08/04/15</u>	<u>Postul2</u>	<u>08/04/15</u>

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR BRACKET

Job Number: 36886A

Part Number: D20135

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/14 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

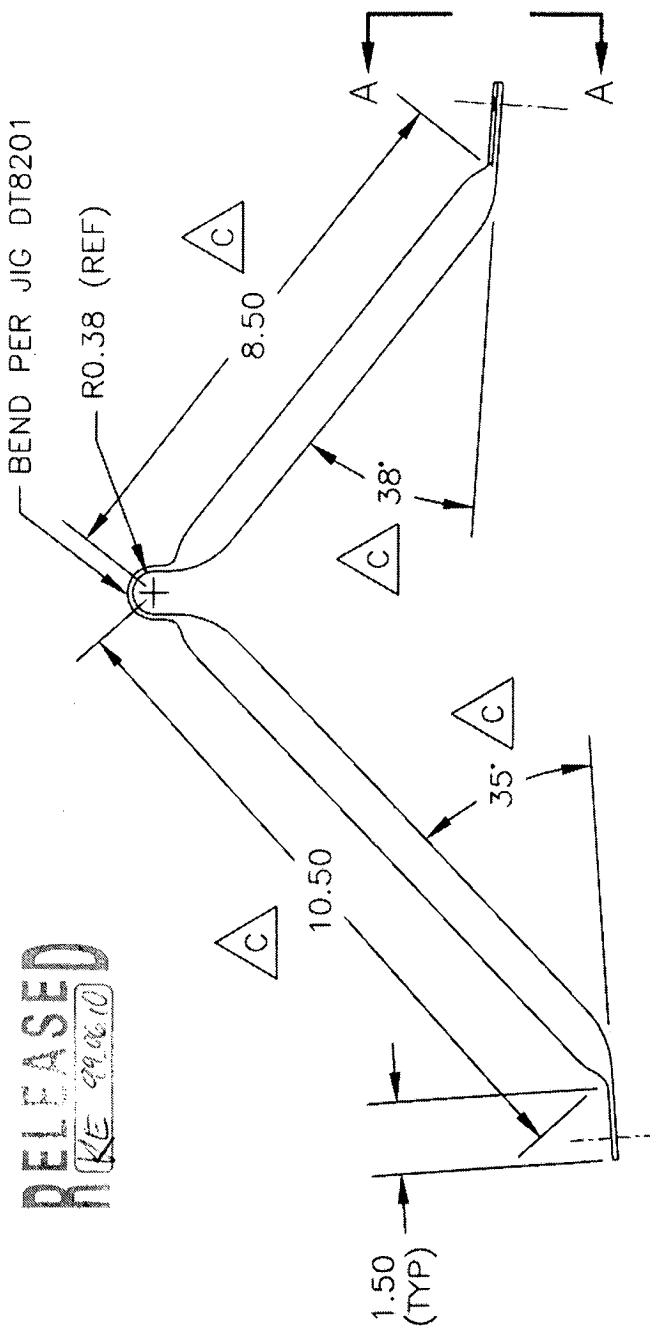
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

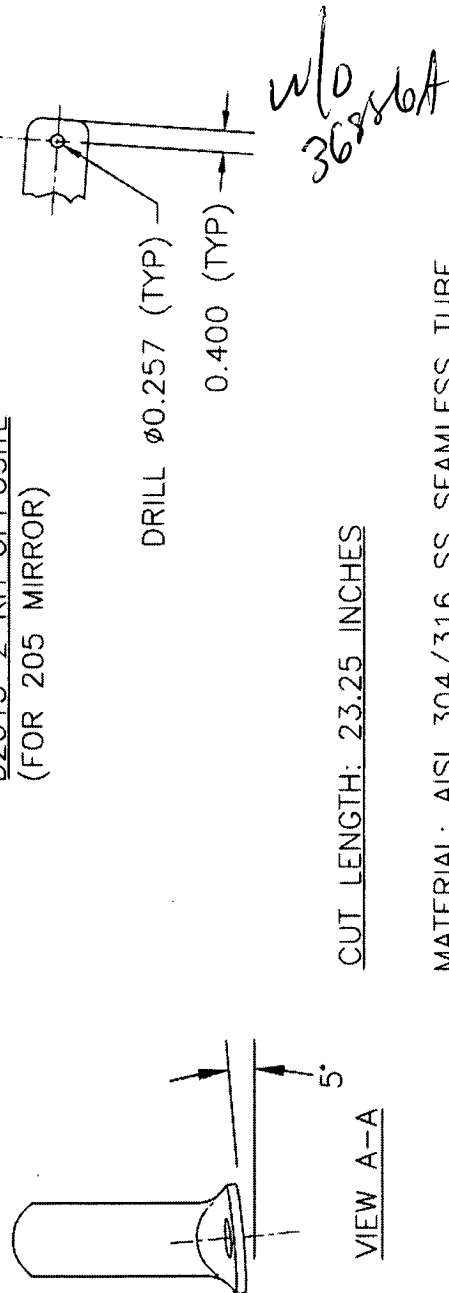
NOTE: Date & initial all entries



DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2013	REV. C SHEET 1 OF 3
DATE 99.06.07		TITLE MIRROR BRACKET	SCALE NTS
A	90.10.22	NEW ISSUE	
B	94.06.15	REDRAWN	
C	99.06.07	REDRAWN, CHANGE OF DIMENSIONS	



D2013-1 LH SHOWN
D2013-2 RH OPPOSITE
(FOR 205 MIRROR)



CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 OD x 0.049 WALL

RELEASED
[Stamp]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

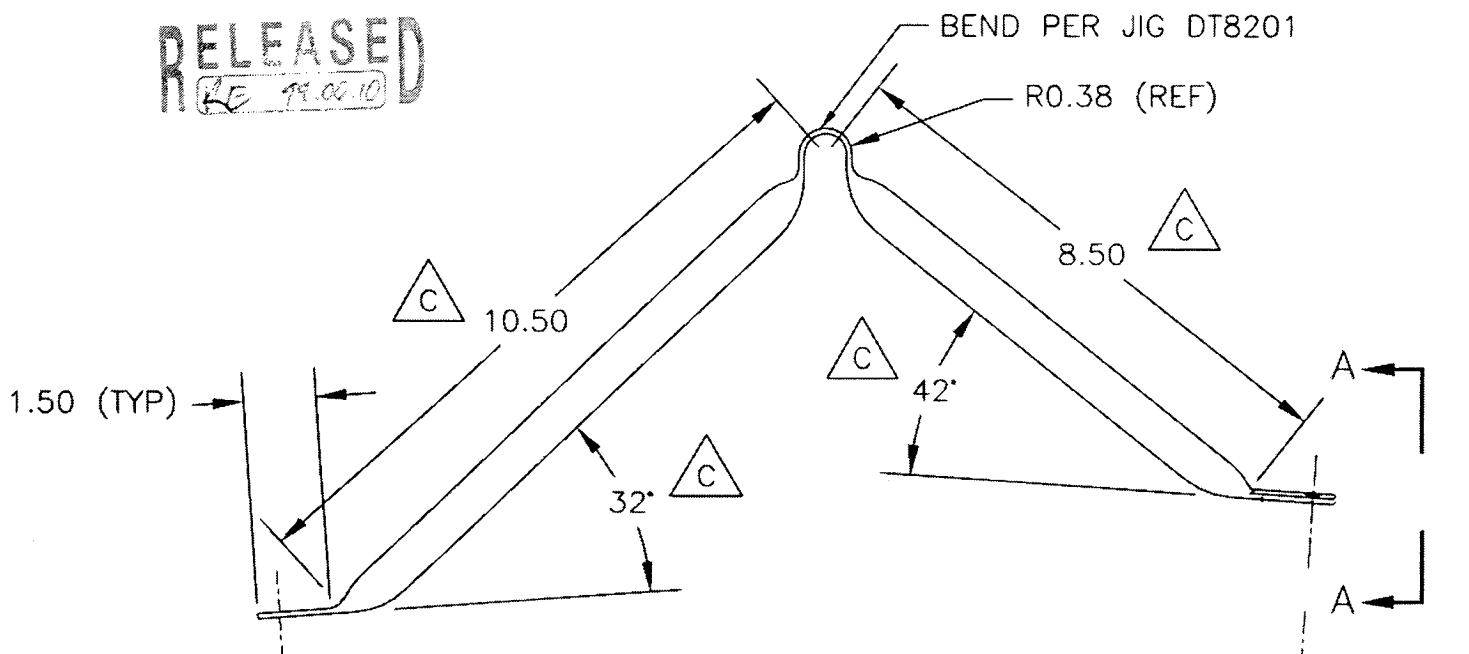
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

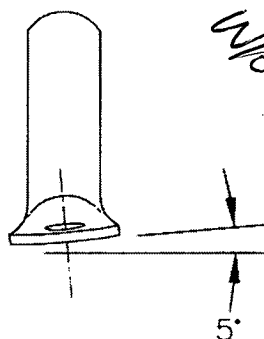
NOTE: Date & initial all entries

RELEASED
LE 11.06.10

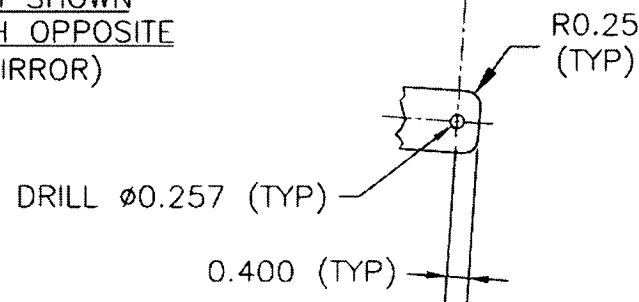
DART



D2013-3 LH SHOWN
D2013-4 RH OPPOSITE
(FOR 212 MIRROR)



VIEW A-A



CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

DESIGN	JB	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED	KE	APPROVED	Y	HAMKESBURY, ONTARIO, CANADA
DATE	99.06.07	DRAWING NO.	D2013	REV. C
TITLE	MIRROR BRACKET	SHEET	2 OF 3	SCALE
				NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

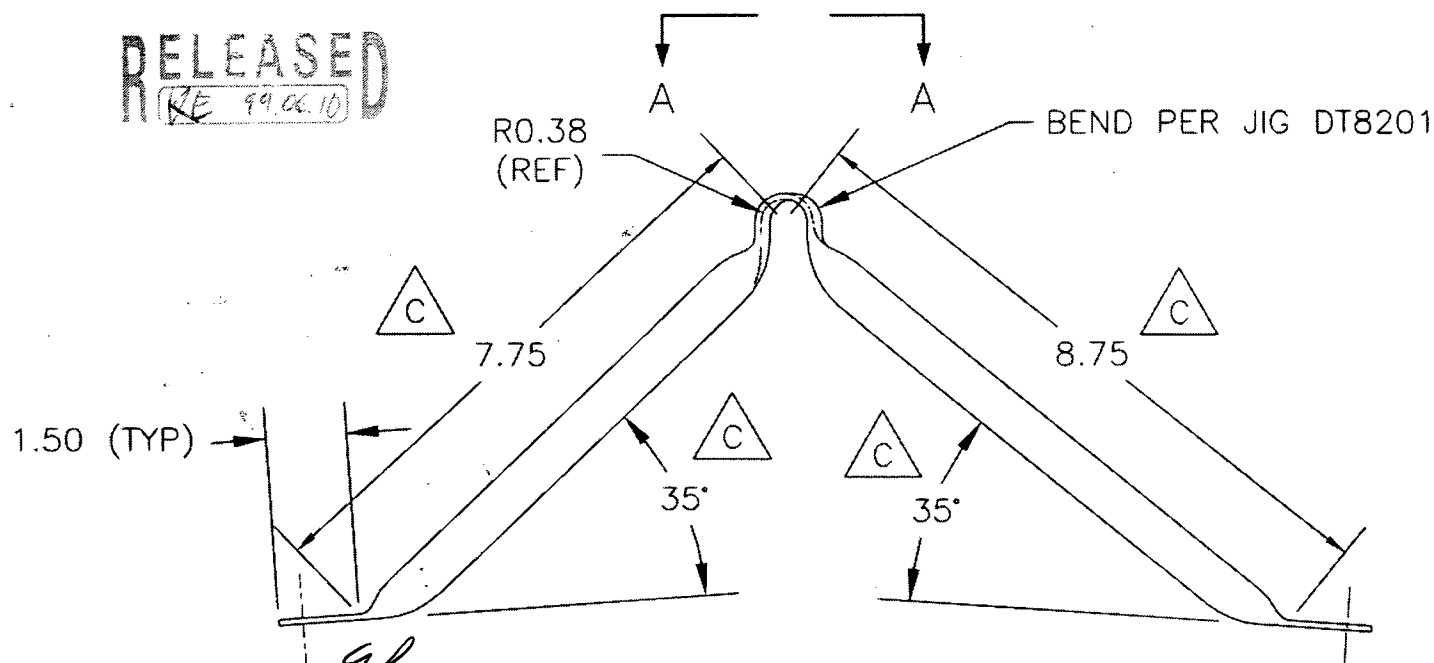
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

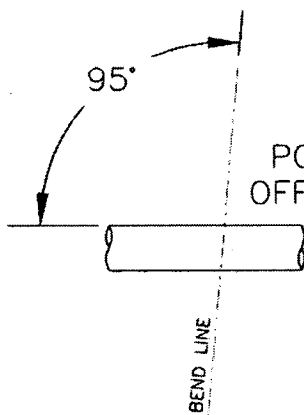
RELEASED
(KE 99.06.10)

DART

ORIGINAL COPY



W/ 36886A



POSITION TUBE
OFFSET 5° IN JIG

D2013-5 LH SHOWN
D2013-6 RH OPPOSITE
(FOR 204 MIRROR)

DRILL $\phi 0.257$ (TYP)

0.400 (TYP)

R0.25
(TYP)

CUT LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

DESIGN	JB	DRAWN BY	RT	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. C
CHECKED	KE	APPROVED		DRAWING NO. D2013	SHEET 3 OF 3
DATE	99.06.07	TITLE	MIRROR BRACKET	SCALE	NIS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries